

Work Order ID 72914

Thursday, August 18, 2011 10:05:00 AM



Page 1

Item ID: D2724-041

Accept



Setup Start



Revision ID:

Stop



Item Name: 206L Step Assembly

Start Date: 8/18/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 8/25/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: *[Signature]*

Date: *11-08-18*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2724	Rev C

100		0.00
-----	--	------



Large Fab

Large Fab

Memo

0.00

Large Fab

Cut D2724-1 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

11.10.14

2 *φ*

110		0.00
-----	--	------



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by

Jig

DT (One End Only)

A/R AL ROD Batch:

Grind end cap welds flush

114514
118735

11.10.14 *2* *φ*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC:

Date:

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Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

2 0 BEH/10/10

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/18/11

2 4

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2x 5 mil 11/10/11
LH

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Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Date:

Date:

Date:

Date:

Insp. Stamp

2 BR 11 10 20

0.00

0.00

0.00

Inspect for foreign object per QSI 024
Weld Remaining end cap as per Dwg D2724 using Jig DT8884 followed by Jig DT
A/R AL ROD Batch: 115414
Grind per dwg D2724

0.00

0.00

Quality Control

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Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8/18/21



190

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2x Ø M-F 11/10/21
LH

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:15
3200 F
8:45

2x Ø M-F 11/10/24
LH

M17745

Dart Aerospace Ltd

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 BR 11-10-24

220

Wing Walk as per dwg QS1005 4.4 Batch 118988 0.00



HandFinish

Memo

0.00

Hand Finishing

2 BR 11-10-24

230

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 Wt of JH 11/10/27

Dart Aerospace Ltd

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

Identify as per dwg & Stock Location: _____

0.00

DDP 72913

11/10/26 p



Packaging

Memo

0.00

Packaging

250

QC21- Final Inspection - Work Order Release

0.00

11/10/26 p



QC

Memo

0.00

Quality Control

ms
11-10-26

Dart Aerospace Ltd

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Picklist Print

Thursday, August 18, 2011 10:05:05 AM

Page 1

Work Order ID: 72914

Parent Item: D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 8/18/2011

Required Date: 8/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2622-120C

Manufactured

No

100

Each

82.7000

1

2



Step Extrusion

Location

Loc Qty

Loc Code

HALL

372131

73

2

64409

6

68293

67

WA

9.7

46910

2

66970

7.7

D2734

Manufactured

No

110

Each

45.0000

1

2



Step End Plate

Location

Loc Qty

Loc Code

WA

373196

45

2

70701

45

D3458-1

Manufactured

No

110

Each

1.0000

2

4



Step Mounting Plate

Location

Loc Qty

Loc Code

WA018

371593

1

4

63075

1

D3458-3

Manufactured

No

110

Each

8.0000

2

4



Step Mounting Plate

Location

Loc Qty

Loc Code

WA018

373327

8

4

63076

8

8/11/10/14

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

Page 2

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Work Order ID: 72914

Parent Item: D2724-041

Parent Item Name: 206L Step Assembly

Start Date: 8/18/2011

Required Date: 8/25/2011

Start Qty: 2.00

Required Qty: 2.00

D2734

Manufactured No

160

Each

45.0000

1

2



Step End Plate



Handwritten signature and date: 8/18/10/20

Location

Loc Qty

Loc Code

WA

B73196

45

70701

45

2

Thursday, August 18, 2011 10:05:05 AM

Shop Packet Print

Page 2

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DART

RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS

- REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE

D2734 END PLATE

TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622 NO. 10717 TYPICAL S
2) WELD PER DART QSI 004 11-08-11 NOT
3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
4) ALL DIMENSIONS ARE IN INCHES
5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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